

Date: Monday, 22/06/2009 10:14:14 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HAT BIN ( BELL 206-L/L1), IVORY
<b>Job Number</b> : 48637A	
<b>Estimate Number</b> : 13677	
<b>P.O. Number</b> :	<b>Part Number</b> : D38451KIV
<b>This Issue</b> : 22/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3845
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 43954	<b>Material</b> : MKYD6185S125P362015
<b>Written By</b> :	<b>Due Date</b> : 24/06/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>mf 09-06-20</u>	
<b>Comment</b> : Est. Rev. A 08.12.03 New Issue DL Est. Rev. B 09/04/15 Thicker Material DL verified by:EC Est Rev C Add Colour Code 09/06/02 DL	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MKYD6185S125P362015	6185 KYDEX .125"
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**Comment:** Qty.: 11.4144 sf(s)/Unit Total : 22.8288 sf(s)  
 6185 Kydex .125" Ivory M 110424

BB 09/06/18

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/18 X2

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

M 09/06/18

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3845 and folio (FTA9255 Prototype ) using tool DT 9255

Dwg. Rev. S.  
 Folio Rev. B

BB 09/06/18 X2

PHD  
 Last Page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/06/2009 10:14:14 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN ( BELL 206-L/L1), IVORY

Job Number: 48637A

Part Number: D38451KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/18 (X2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

OK 09/06/18

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

OK 09/06/19

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

OK 09/06/19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlozet 12

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

IN THERMOFORMING  
Waiting Packaging

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



h 09/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3845-1KIV PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 10.02.24

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>48637A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/24	7.0	DRAWN PORTION OF HAT BIN IS THIN + SDA	<u>[Signature]</u> Q55 042 09.06.24	REINFORCE AFFECTED SECTIONS PER ATTACHED INSTRUCTION BASED ON TR-D107-761 REV A	<u>[Signature]</u> 09/06/24	S 02/06/24	<u>[Signature]</u> Q55 042 09.06.24	S 09/06/24

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 48637A
Description:	Part Number: D3845-1K1U
Inspection Dwg: D3845 Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wk Date: 08/06/18

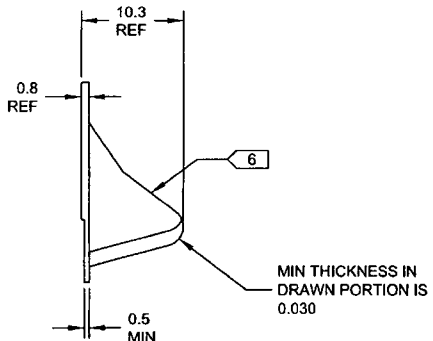
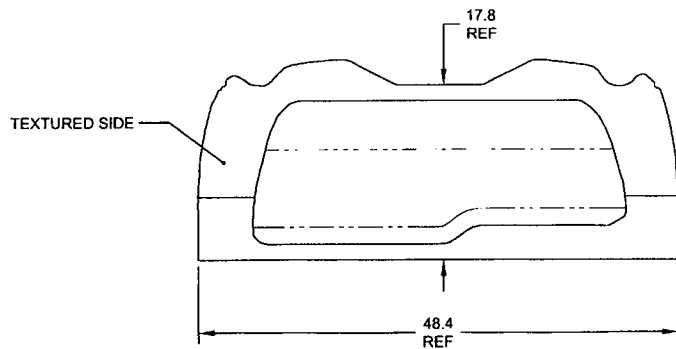
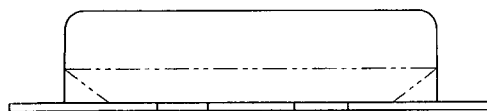
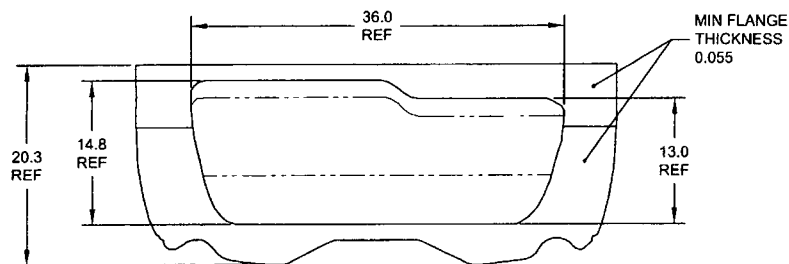
### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5"	MIN.	0.475"				
0.055"	MIN.	0.105"				
0.030"	MIN.					See Attached

Measured by: Wk Date: 08/06/18  
 Audited by: BB Date: 09/06/18  
 Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

8 7 6 5 4 3 2 1



RELEASED

**D3845-1 HAT BIN**  
(BELL 206 L/L1)

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 5.3 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3845-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3845-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

REV.	DESCRIPTION	BY	DATE
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3845-1KIV AND ADD STEEL GRAY P/N D3845-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.22
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3845  
REV. C  
SHEET 1 OF 1  
TITLE HAT BIN (BELL 206 L/L1)  
SCALE NTS

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8 7 6 5 4 3 2 1

With reference to Test Report, TR-D407-781-1 Rev. A, the following may be performed to reinforce the drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.

Kydex 6185 reinforced with 9 oz cloth using Hysol 9330 A/B and ATH208  
Procedure:

- 1) Abrade smooth side of Kydex 6185 with scotchbrite and clean with acetone
- 2) Mix Hysol 9330 – Part A to Part B – 100% to 33% by weight in accordance with manufacturer's instructions

Hysol 9330 (2 part system)

BATCH # M 112099

- 3) Mix item 2) with ATH208 (Aluminum TriHydrate) at 50% by weight

ATH208

BATCH # M 110065

Ex:

100 grams of Hysol 9330 Part A + 33 grams of Hysol 9330 Part B = 133 grams of Hysol 9330

Therefore, use 133 grams of ATH208

- 4) Saturate 1 layer of 7781 9oz glass Cloth (item # FG778150550ROL) with mixture of Hysol 9330 and ATH208

9oz glass Cloth

BATCH # M 111166

- 5) Apply item 4) to reinforce drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.
- 6) QC 5

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 49634 A

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